

34356 DREV

Work Order ID 53120



October 22, 2009 12:53:57 PM

Item ID: D3072-2

Accept



Setup Start



Revision ID: A1

Stop



Item Name: Bracket

Start Date: 22/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: PL

Date: 9-10-22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3072

Rev A1

(P10) →

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3072 (D3072-101 flat pattern) ☐ Dwg
Rev: A1 ☐ Prog Rev: A1 ☐ 2-Deburr if necessary

13 9-10-28

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

13 9-10-28

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) 809/10/28

(11)

hook
Qty x1
For
QC temp tree

W/O: 53120		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/10/22	#120	took qty & part for QC inspection Template	S	09/10/22	1	[Signature]	[Signature] 09/10/22

7 D119-696

Part No: D3072-2 PAR #: _____ Fault Category: Small Fabs NCR: (Yes) No DQA: _____ Date: 05-12-17

Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 05-12-17

NCR: 53120		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/12/07	130	1 part at the set up was out of Tolerance R.C process	[Signature] 09/12/07	Scrap & destroy No replace	[Signature] 09/12/07	[Signature] 09/12/07	[Signature] 09/12/07	[Signature] 09/12/07

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1- deburr if necessary 2- Bend as per dwg D3072

09/12/07

10

12

140



QCS- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

08/08/10

410

12

150



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

09-12-10

10

Work Order ID 53120

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Item ID:	D3072-2	Accept		Setup	Start	
Revision ID:	A1				Stop	
Item Name:	Bracket					
Start Date:	22/10/2009	Start Qty:	10.00	Cust Item ID:		
Required Date:	30/10/2009	Req'd Qty:	10.00	Customer:		
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: 10:03 320° FINISH TIME: 10:35	0.00 0.00	BR 09-12-11			(10)			
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	all ok			(10)	2		
180 Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00				9/12/11	10:25		

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Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/14 AJ

1009-12-11

10

Picklist Print

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Work Order ID: 53120



Parent Item: D3072-2RevA1



Parent Item Name: Bracket

Start Date: 22/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.090		Purchased	No			100	sf	73.5000	1.2284	1.500		
5052-H32 .090 Sheet												

LB 9-10-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

73.5

100782

41.5

3019

32

100782

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

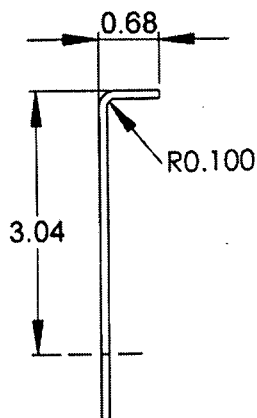
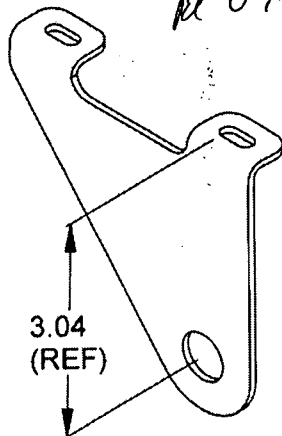


DART

53120

09-10-22

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3072	REV. A SHEET 1 OF 1
DATE 01.12.16	TITLE BRACKET		SCALE 1:1
A	01.12.16	NEW ISSUE	
AI 02.01.18		ADD FLAT PATTERN PART NUMBER # CP	

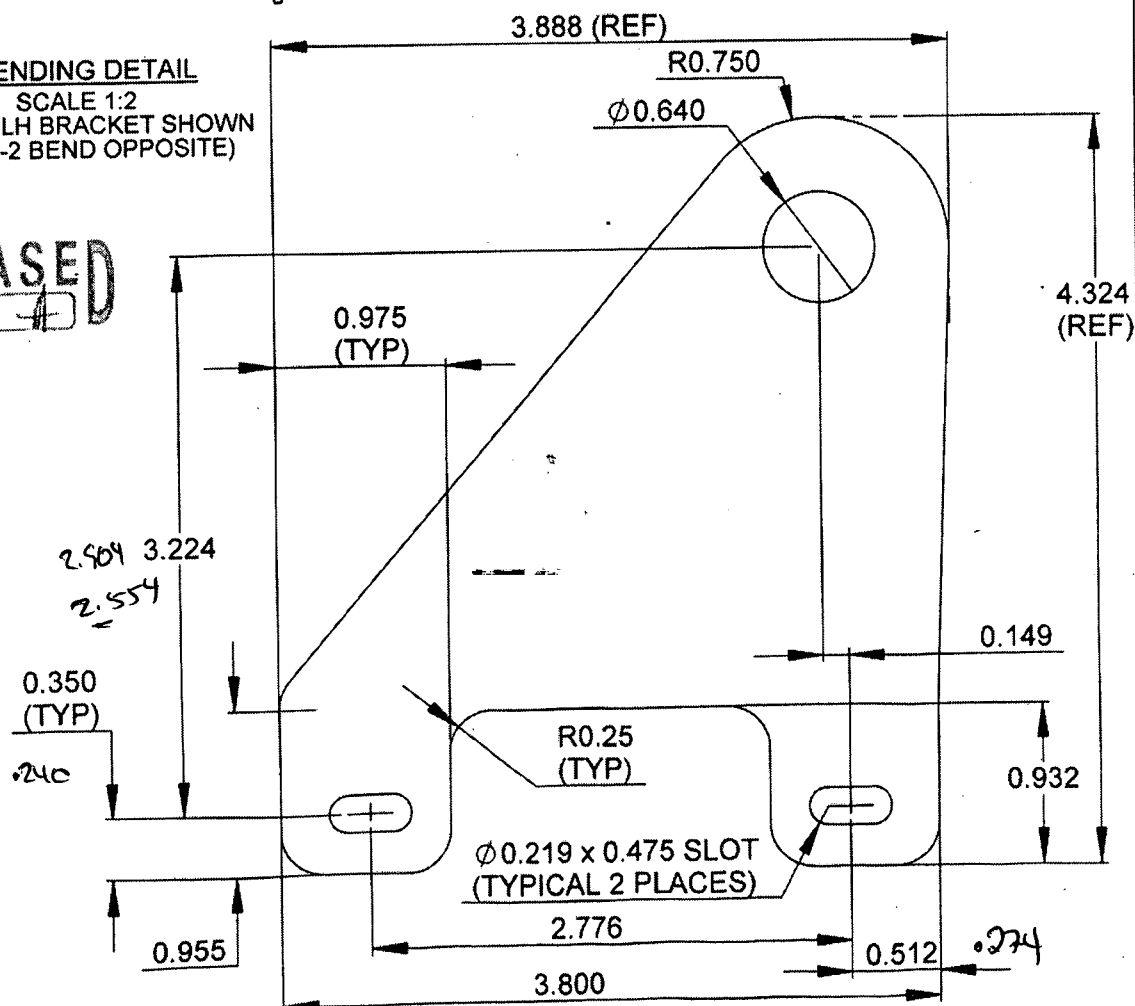


D3072-1/-2 BRACKET

- 1) MATERIAL: 5052-H32/H34 (AMS 4016/4017/ QQ-A-250/8) 0.090 THICK
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

BENDING DETAIL
SCALE 1:2
D3072-1 LH BRACKET SHOWN
(D3072-2 BEND OPPOSITE)

RELEASED
02.01.15



D3072-101

FLAT PATTERN FOR D3072-1/-2

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